

WHAT IS CLAIMED IS:

1. A method for preparing a moisture barrier fabric, comprising:
 needling a woven fabric with a needle having at least one barb sufficient to entangle the fibers of the woven fabric.
2. The method of claim 1, wherein the needling is in a direction substantially opposite an advancing direction of the fabric.
3. The method of claim 2, wherein the barbs are oriented generally in the direction of needling, and penetrate the fabric in a direction substantially opposite the advancing direction of the fabric.
4. The method of claim 3, wherein the needle comprises at least one barb having a barb angle of about 20 °.
5. The method of claim 1, wherein the needling comprises piercing the fabric with multiple needles arranged in a staggered arrangement.
6. A method for preparing a moisture barrier fabric, comprising:
 contacting a woven fabric with a washing solution comprising:
 a detergent; and
 sodium carbonate.
7. The method of claim 6, wherein the detergent is nonionic.
8. The method of claim 6, wherein the contacting occurs at a temperature of about 120 °F.

9. The method of claim 6, wherein the contacting occurs in a soaping vat, and further comprising rinsing the fabric in water or an aqueous solution in one or more rinsing chambers.
10. The method of claim 7, wherein the nonionic detergent is present in a concentration ranging from about 0.05 to about 1.00 g/L of the washing liquid.
11. The method of claim 10, wherein the nonionic detergent is present in a concentration of about 0.25 g/L of the washing liquid.
12. The method of claim 6, wherein the sodium carbonate is present in a concentration ranging from about 0.75 g/L to about 1.5 g/L of the washing liquid.
13. The method of claim 12, wherein the sodium carbonate is present in a concentration of about 1.25 g/L of the washing liquid.
14. A method for preparing a moisture barrier fabric, comprising:
applying at least one coating to a side of a woven fabric, the coating comprising an aqueous latex emulsion of blend of acrylic and polyurethane polymers having a curing temperature ranging from about 250 °F to about 275 °F.
15. The method of claim 14, further comprising curing the acrylic-polyurethane copolymer.
16. The method of claim 14, wherein at least two coatings of latex emulsion are applied to the woven fabric.
17. The method of claim 14, wherein the latex emulsion has a viscosity of at least 20,000 cp.

18. The method of claim 17, wherein the latex emulsion has a viscosity of at least 30,000 cp.

19. The method of claim 18, wherein the latex emulsion has a viscosity of at least 40,000 cp.

20. The method of claim 19, wherein the latex emulsion has a viscosity of at least 50,000 cp.

21. The method of claim 20, wherein the latex emulsion has a viscosity of at least 60,000 cp.

22. A method for preparing a moisture barrier fabric, comprising:
immersing a fabric comprising a woven facecloth and a latex backing in a treatment solution comprising a fluorochemical.

23. The method of claim 22, wherein the treatment solution further comprises a stainblocker.

24. The method of claim 22, wherein the treatment solution further comprises a wetting agent.

25. The method of claim 22, wherein the treatment solution further comprises a polyurethane.

26. The method of claim 22, wherein the fluorochemical is present in the treatment solution in an amount ranging from about 10 wt% to about 15 wt% based on the total treatment solution.

27. The method of claim 25, wherein the polyurethane is present in the treatment solution in an amount ranging from about 10 wt% to about 15 wt% based on the total treatment solution.

28. The method of claim 22, wherein the fluorochemical is nonionic.
29. The method of claim 23, wherein the stainblocker is anionic.
30. The method of claim 23, wherein the stainblocker comprises a polymer of (meth)acrylic acid.
31. The method of claim 24, wherein the wetting agent is a non-rewetting wetting agent.
32. A method for preparing a moisture barrier fabric, comprising:
immersing a fabric comprising a woven facecloth and a latex backing in a treatment liquid comprising a polyurethane.
33. The method of claim 32, wherein the polyurethane is present in the treatment liquid in an amount ranging from about 10 wt% to about 15 wt% based on the total treatment solution.
34. The method of claim 32, wherein the polyurethane is present as an emulsion.
35. The method of claim 32, wherein the polyurethane is ethoxylated.
- ✓ 36. A method for preparing a moisture barrier fabric, comprising:
needling a woven fabric with a needle having at least one barb sufficient to entangle the fibers of the woven fabric;
contacting the needled woven fabric with a washing solution comprising:
a detergent; and
sodium carbonate;
applying at least one coating to a side of a woven fabric, the coating comprising an aqueous latex emulsion of an acrylic-polyurethane copolymer having a curing temperature ranging from about 250 °F to about 275 °F;

immersing a fabric comprising a woven facecloth and a latex backing in a treatment solution comprising a fluorochemical and a polyurethane.

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